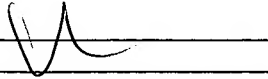


Date: Friday, 23/11/2007 7:43:05 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MOUNTING ANGLE
Job Number :	35969		
Estimate Number :	10415		
P.O. Number :	N/A	Part Number :	D2417
This Issue :	23/11/2007	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2417 REV. B
First Issue :	N/A	Project Number :	N/A
Previous Run :	26908	Drawing Revision :	B
	Type :	Material :	N/A
	SMALL / MED FAB	Due Date :	30/11/2007
Written By :			
Checked & Approved By :			
Comment :	Est:C 03.04.14 Reformat; Incorporated D2292; D2375-3-08-106; D2403 - D2417 KJ/RF Est Rev:D Now on WaterJet 06-05-18 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 0.0411 sf(s)/Unit Total : 0.8211 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick

(M2024T3S.063)

Batch:

M101022 HB 07-11-26

Identify for D2417

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D2417

Dwg Rev: B

Prog Rev: B

HB 07-11-26

20

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



HB 07-11-26

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

counters
 07/11/26 (20)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

07/11/26 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PP Date: 01/11/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/11/2007 7:43:05 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 35969

Part Number: D2417

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D2416

SB

07/11/27

(20)

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr hole

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/11/27

counters

(x20)

9.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JS

07-11-28

(20)

(x20)

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

BL

07-11-28

(20)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST32

U

RS 07/11/28

(x20)

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/28




(20)

Job Completion

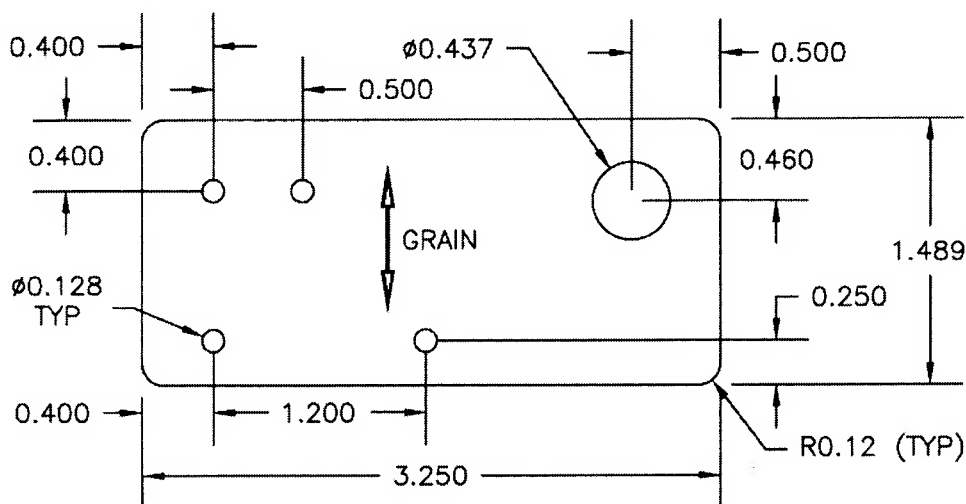


U 07/11/29



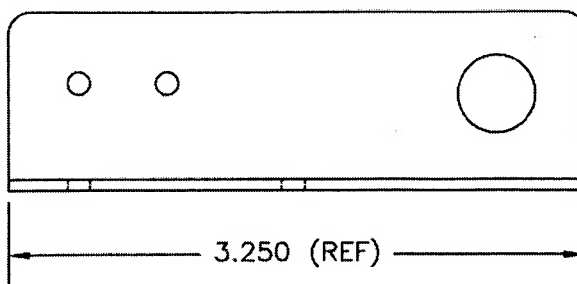
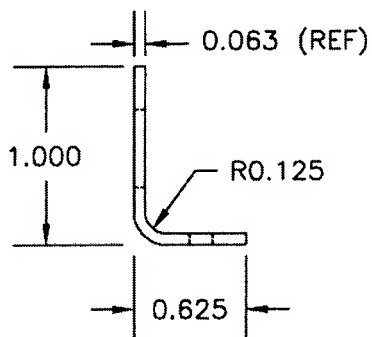
DESIGN BW	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2417	REV. B SHEET 1 OF 1
DATE 03.04.09		TITLE MOUNTING ANGLE	SCALE 1:1
A	95.04.06	NEW ISSUE	
B	03.04.09	ADDED Ø0.128 & FLAT PATTERN	

RELEASED
03.05.07 #



FLAT PATTERN

W/O ~~4~~
35969



BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3/T3511 0.063" THICK PER QQ-A-250/4 (REF DART SPEC: M2024T3S.063)
- 2) FINISH: ACID ETCH AND ALODINE AS PER DART QSI 005 4.1
- 3) DEBURR ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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